

48

Date: Tuesday, 10/30/2007 2:46:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID
 Job Number : 35424
 Estimate Number : 10549
 P.O. Number : N/A Part Number : D206642311
 This Issue : 10/30/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 35420 Material : N/A
 Due Date : 11/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: J05.10.11 Added D3429-1 per CHG004 KJ/CP/JL
 M/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



RS 07.11.01 (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-311 CHG004

7/12/06

2.0 35424A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE
 D206-642-341 B 35424A

CU

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0 D2652 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
 BUSHING

Pick:

Qty Part Number Description Batch
 24 D2652 Bushing
 1 D206-642-341(REF)

34893
 35424A

60

5.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 TOW RING

Pick:

Qty Part Number Description Batch
 1 D2655 Tow Ring

34613

7/12/06 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 35424

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG ASSEMBLY

Pick:

Qty Part Number

Description

Batch

2 D2659

Lug Assembly

32018

W

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

34628

W

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

34002

W

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

34629

W

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

34630

W 7/14/07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 35424

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

34174

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

34617

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

34632

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

TOW RING

Pick:

Qty Part Number

Description

Batch

1 D2968-043

Tow Ring

~~34632~~ B32503

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4 AN3-37A

Bolt

M103947 3x M104016 1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 35424

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

8

AN3-41A

Bolt

M105810

17.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

1

AN4-5A

Bolt

M100857

18.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

12

AN4-6A

Bolt

M104322

19.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4

AN5-10A

Bolt

M104156

20.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

8

AN5-11A

Bolt

M105810

W/O:		WORK ORDER CHANGES					
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Job Number: 35424

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

4 AN5-12A

Description

Bolt

Batch

M104885

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty Part Number

12 AN960JD10

Description

Washer

Batch

M105792

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty Part Number

1 AN960JD1016

Description

Washer

Batch

M5519

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

Pick:

Qty Part Number

25 AN960JD416

Description

Washer

Batch

M105906

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number

8 AN960JD516

Description

Washer

Batch

M104156

6/7/12/04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 35424

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	M105952

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description	Batch
12	MS21042L3	Nut	M105558

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description	Batch
13	MS21042L4	Nut	M105054

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-311

Location: 0

PPP Rev: 0

7/12/06 50 (1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 35424

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done 12/06

Job Completion



12/12/06

B35424A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

48

Date: Tuesday, 10/30/2007 2:46:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
Job Number : 35424A
Estimate Number : 10539
P.O. Number : N/A Part Number : D206642341
This Issue : 10/30/2007 S.O. No. : N/A Drawing Number : D2650 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : E
Previous Run : 35420A Material : N/A
Written By : Due Date : 11/30/2007 Qty: 1 Um: Each
Checked & Approved By : 071031
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JL
M

Additional Product

Job Number:



Seq. # Machine Or Operation Description

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341 CHG002

HR

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B34692

DP

7-10-31

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2647

Fwd Cap

B29328

BE 07-10-31

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod

M 105138

BE 07-10-31

4-Grind weld flush to cap on top surface only.

BE 07-10-31

DP 7-10-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:46:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B). Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

SL 7-11-1
SL/H 7-11-1

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 7-11-1

6.0

D26545

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-5

Web

35476

SL 7-11-8

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 7-11-8 Time: 7:30

Finish Date: 7-11-8 Time: 7:30 AM

A/R Sikaflex-291

105488

Sikaflex expiry date: 8-7-1

SL 7-11-1
SL 7-11-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 9/16/07

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

19 D2649

Crossbolt spacer

BE 034508

BE 07/11/14

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod *M105138*

BE 07/11/14

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

SL 7-11-15

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

33061

①

SL 7-11-15

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

103525

② SL 7-11-15

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 M7885/3-4-3

Rivets

102513

(2)

SL 7-11-15

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

SL 7-11-15

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

B

07-11-20

16.0

QC5

INSPECT WORK TO CURRENT STEP



Pre-checked



Comment: INSPECT WORK TO CURRENT STEP

C

7/11/20 (SL)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL

07-11-22

(SL)

18.0

POWDER COATING

POWDER COATING



MA 105914



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

BL

07-11-22

Q

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-22

(SL)

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B33992

HL

21.0

D265611

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-11

Wearshoe

B32818

HL

07-11-22 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description:

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B34171

isl

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-35

Wearshoe B29337

*

sl

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B34012

sl

25.0

ALS41032130

Insert



Comment: Qty.: 54.0000 Each(s)/Unit Total: 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 ALS4-1032-130

Inserts M105729

or (see QSI 017)

sl

26.0

AN960JD10L

Washer



Comment: Qty.: 54.0000 Each(s)/Unit Total: 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 AN960JD10L

Washer M104374

sl

07-11-22

(21)

0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:46:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS27039108

Screw



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 MS27039-1-08

Screw

M105076

JS

28.0

D26511

Plug



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-1

Plugs

(10x) B33349
~~2 batches~~ (4x) B33185

JS

29.0

D26513

O-Ring



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-3

O-Rings

B34592

JS

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M105426

JS

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M15194

JS

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

JS

07-11-22

JS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:46:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2646

Aft Cap

1331335

*

13

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer M104374

13

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw M105676

13

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M105585

Sikaflex expiry date: 08-07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650.

Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 M105585

Sikaflex expiry date: 08-07

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M106030

BR/

07-11-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:46:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 35424A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/11/06 (1)

37.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6/11/06 (1)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PDP 35424

6/12/06 (1)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/12/06 (1)

Job Completion



6/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
16 04 17 *PH*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

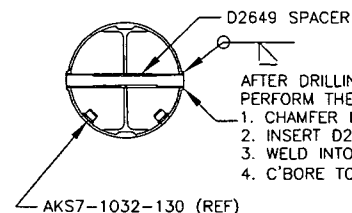
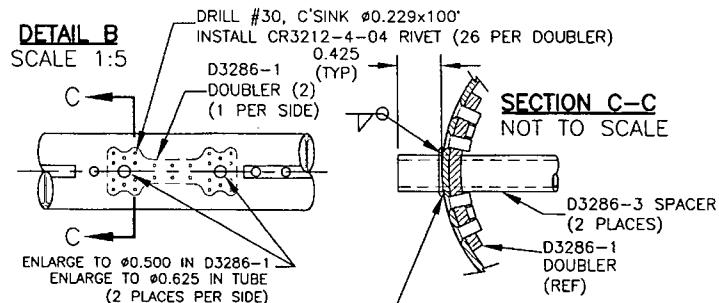
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DETAIL A
SCALE 1:5

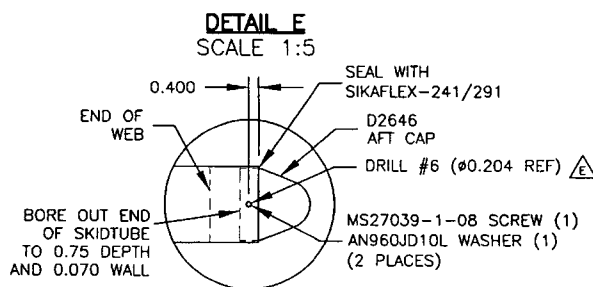


DETAIL D
FOR Ø0.375 HOLES ONLY

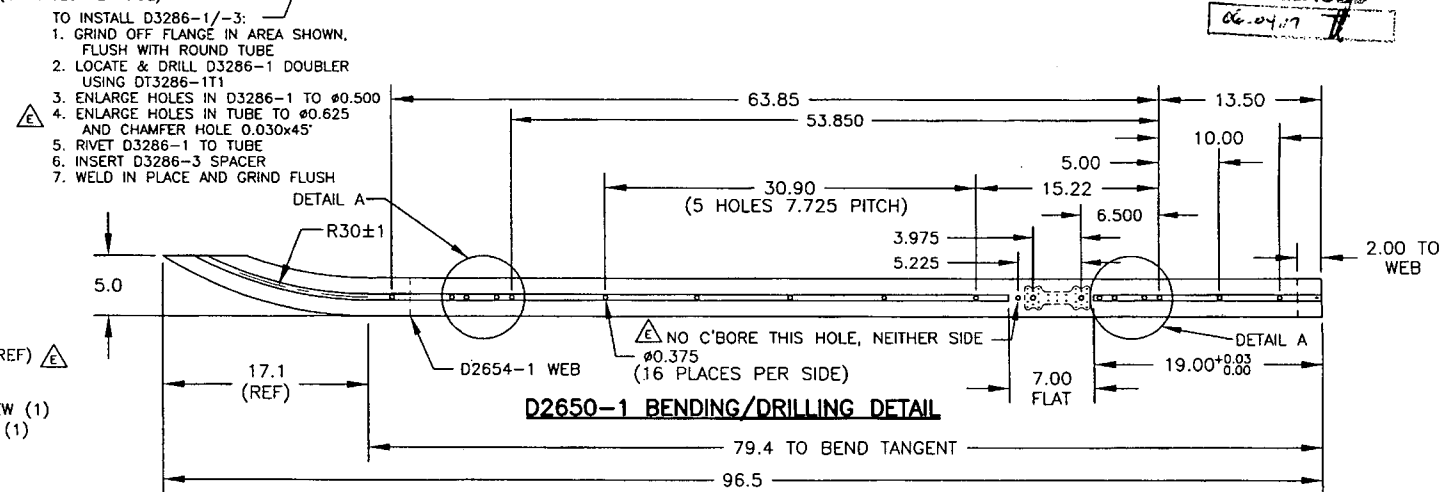
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313 X 0.75 DEEP

RELEASED

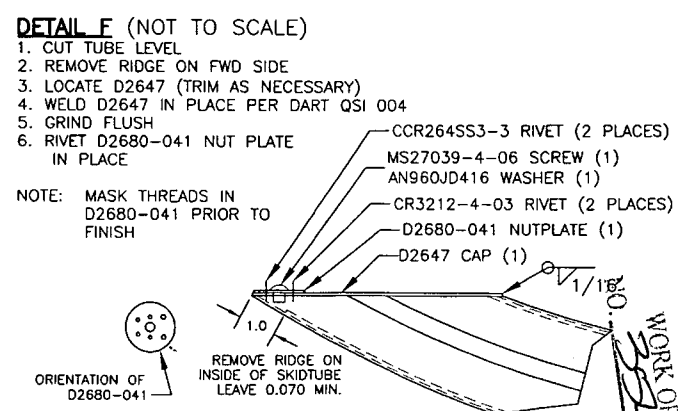
06-0417



DETAIL E
SCALE 1:5



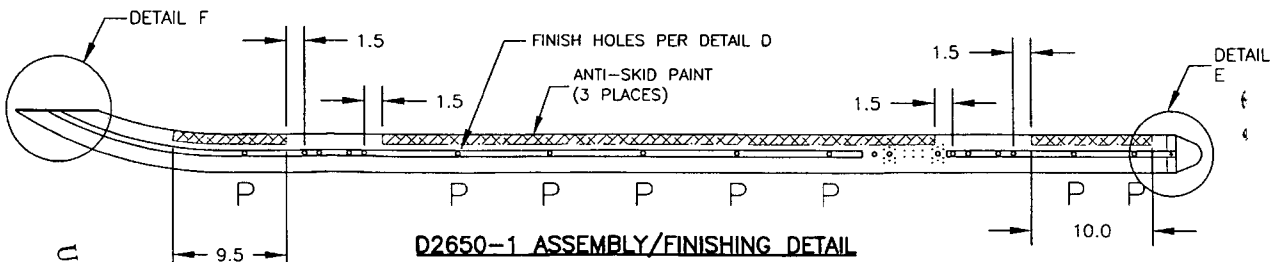
D2650-1 BENDING/DRILLING DETAIL




DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

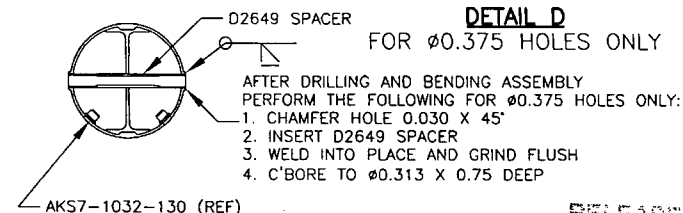
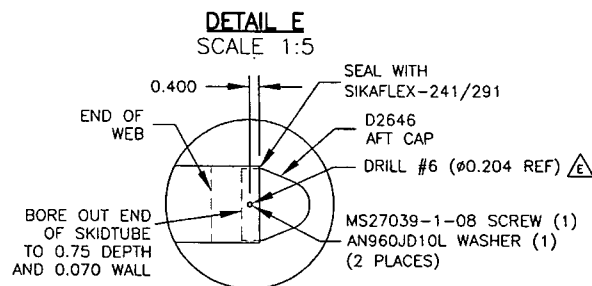
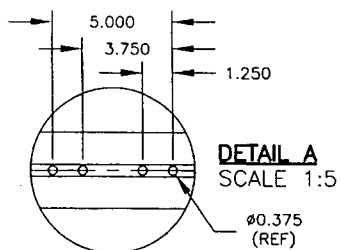
NOTE: MASK THREADS IN
D2680-041 PRIOR TO
FINISH



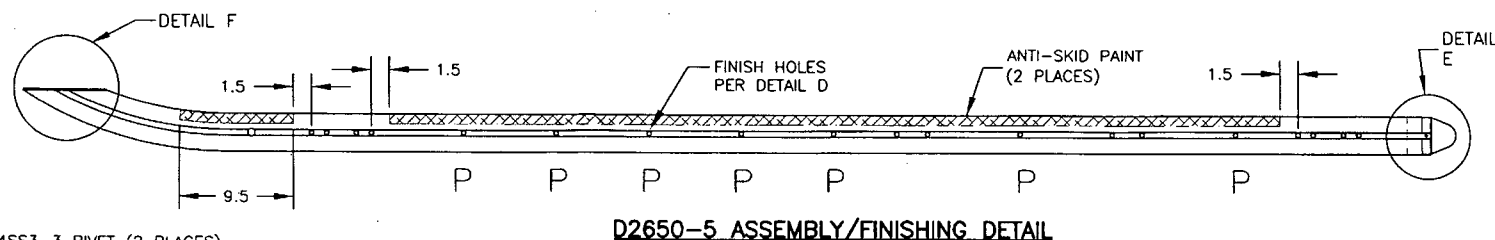
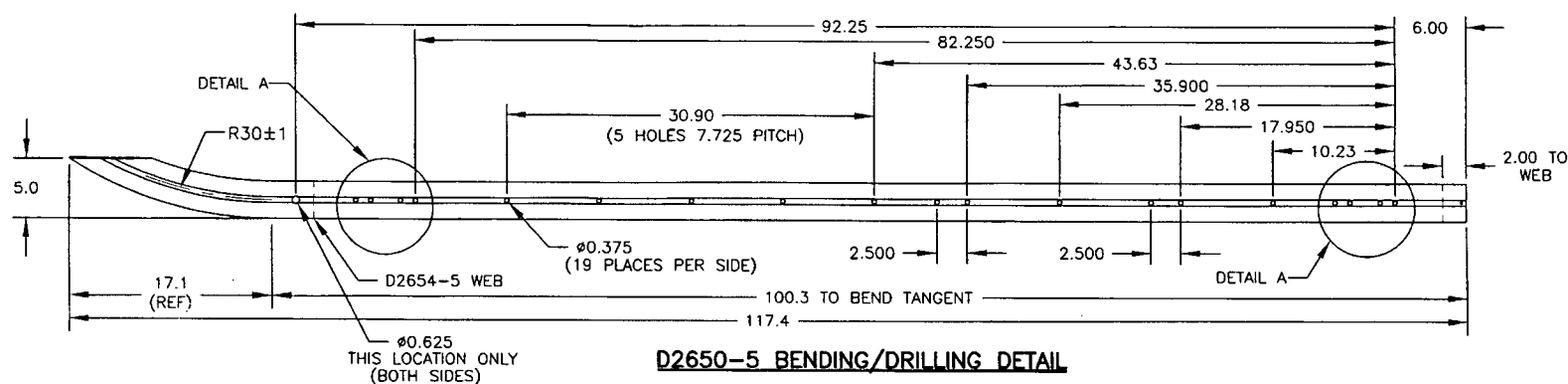
D2650-1 ASSEMBLY/FINISHING DETAIL

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	CHECKED <i>PL</i>	APPROVED <i>HT</i>		DRAWING NO. D2650	REV. E SHEET 2 OF 5
	DATE 06.03.30			TITLE SKIDTUBE	SCALE 1:10

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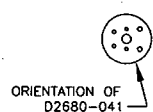
RELEASED
24.12.11



DETAIL F (NOT TO SCALE)

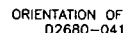
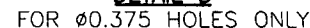
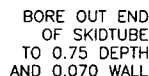
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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DATE 06.03.30		TITLE SKIDTUBE		SCALE 1:10	



MASK THREADS IN D2680-041 PRIOR

DART		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2650		REV. E SHEET 5 OF 5	
TITLE SKIDTUBE		SCALE 1:10	

RESULTS

000419 #

